

5/46

D3159-043

DART AEROSPA		Work Order:	24707	
Description: Bracket		Part Number:	D3159-043	
Note: D3159-043 / -044		(P B30-23000-259)		
Drawing: D3159 Rev E		Stack of 7		
Step	Location	Qty:	By	Date
1	EXPEDITING	7	DJ	05.10.26
2	HAAS	of 7 pick.		
3	QC	Inspect Level 2	J.L.	05.11.12
4	QC	Inspect Level 8	J.L.	05.11.13
5	METAL / CNC-CELL	Deburr break all unmarked sharp edges .005 to 0.010	SAD	05.11.13
6A	METAL	Form as per drawing (Note: -043 SHOWN)	SB	05/11/14
6B	GA	C'sink holes as per dwg. D3159	FF	05/11/15
7	FINISHING	Chemical conversion coat as per QSI 005 4.1	FF	05/11/15
8	STORES	Pick: Qty Part number Description Batch 1 MS21061L06 Nutplate M11735 2 MS20426AD3-4 Rivet M15786	FF	05/11/15
9	METAL	Assemble as per dwg.	FF	05/11/15
10	QC	Inspect Level 5	PP	05.11.16
11	STORES	Identify and stock with P/N + G/N using fine point permanent ink marker Loc. 88	PP	05/11/16
12	EXPEDITING	Close W/O Inspect level 21 Cost/part 1.18 Due 05/11/21 (7) (19) 05/11/22		7

Rev	Date	Change	Revised By	Approved
A	02.05.13	New Issue	NG	20.05.2022/5/13
A1	03.03.20	Added c'sink	RF	03.03.20

RELEASED

02/05/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
05-11-16	6A	-043 Dwg is now A -044. -043 bend is going to be opposite. Dwg change is in process by Roberto. W/O has went from -043 to A -044.	<i>[Signature]</i>	NP		1 05-11-16	2 05-11-16

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 05/11/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

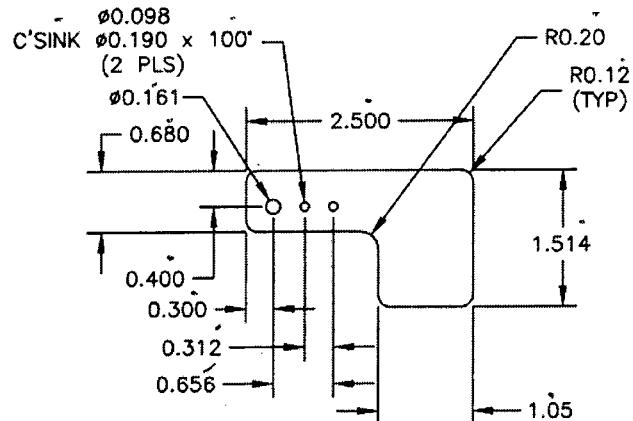
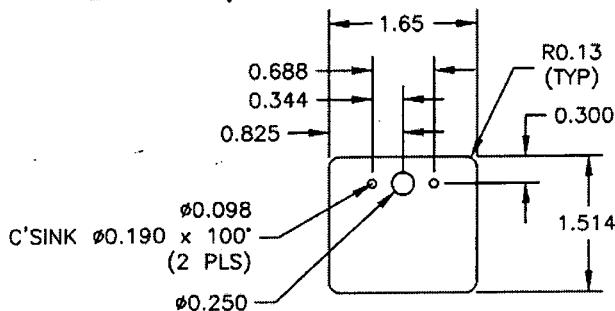


COPYRIGHT
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3159 REV. B SHEET 1 OF 1
DATE		TITLE SCALE 04.10.18 BRACKET ASSEMBLY 1:2

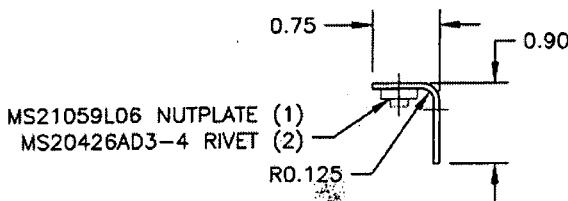
RELEASED
04.11.23

A	02.04.30	NEW ISSUE
B	04.10.18	ADD PART MARKING

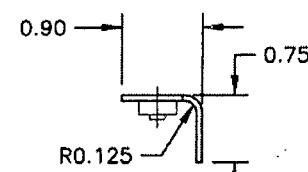
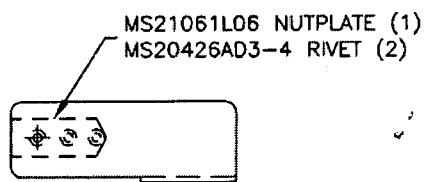


D3159-1 BRACKET FLAT PATTERN

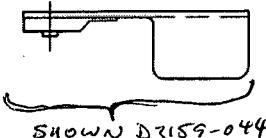
D3159-3/-4 BRACKET FLAT PATTERN



D3159-041 BRACKET ASSEMBLY



KF
05.11.16



VIEW D3159-043
SIDE CUT

D3159-043 BRACKET ASSEMBLY (SHOWN) TURN TO
REPLACES PREMIER P/N B30-23000-259
(D3159-044 BRACKET ASSEMBLY (OPPOSITE)).
REPLACES PREMIER P/N B30-23000-260

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY D3159-041/-043/-044 WITH DART P/N USING FINE POINT PERMANENT INK MARKER

24707

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 26, 2005
03:12 pm

Work Order No	:	0024707	Department Code:
Project Name	:	D3159-043	Burden Flags : NNNNNNN
Project For	:	WK546	WO Status : Open
Work Order Type	:	Main	Invoice State : Not Invoiced
Main WO Number	:		Invoice Date :
House Part Number	:	D3159-043	Invoice Number :
Description	:	Bracket Assembly	Invoice Amount : 0.00
Manufactured	:	Yes	
Amount Req'd	:	2	
Amount Done	:	0	Order Entry No :
Start Date	:	10-26-05	OE Value : 0.00
Est Finish Date	:	11-15-05	
Act Finish Date	:		Est Mark Up : 0.000%
Drawings Reqd	:	No	Actual Mark Up : 0.000%
Ok for Approval	:		
Approval Rec'd	:		\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden	: 0.00	0.00	0.00		
<hr/>					
Total Cost	: 0.00	0.00	0.00		
Mark up	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/ (Loss)	: 0.00	0.00

DART AEROSPACE LTD

Work Order: 24707

Description: bracket assembly

Part Number: A3159-043

Inspection Dwg: A3159

Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article

1

Prototype

Measured by:

JL

Audited by:

2

Prototype Approval:

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Ensayos

05.11.13

Date:

05/11/12

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

Date: Thursday, 11/17/2005 6:00:34 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: BRACKET ASSEMBLY		
Job Number	: 24707			Part Number	: D3159044		
Estimate Number	: 10682			Drawing Number	: D3159 REV B		
P.O. Number	:			Project Number	:		
This Issue	: 11/17/2005	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: R & D SM/MED FAB	Due Date	: 11/24/2005	Qty:	7 Um: Each
Previous Run	:						
Written By	:						
Checked & Approved By	:						
Comment	: Est A 02.05.13 New Issue NG						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S063	6061-T6 .063 Sheet
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA238		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Deburr break all unmarked sharp edges .005 to 0.010 Form as per drawing (Note: -044 OPPOSITE) C'sink holes as per Dwg D3159		

Date: Thursday, 11/17/2005 6:00:34 PM
User: Linda Lacelle

Process Sheet

Customer: GU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 24707

Part Number: D3159044

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0 MS21061L06

Nutplate

8.0 MS20426AD34

RIVET

9.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg.

10.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: _____

12.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
12:45 pm

Work Order No	:	0024707	Department Code:
Project Name	:	D3159-044	Burden Flags : NNNNNNNN
Project For	:	WK546	WO Status : Open
Work Order Type	:	Main	Invoice State : Not Invoiced
Main WO Number	:		Invoice Date :
House Part Number	:	D3159-044	Invoice Number :
Description	:	Bracket Assembly	Invoice Amount : 0.00
Manufactured	:	Yes	
Amount Req'd	:	2	
Amount Done	:	0	Order Entry No :
Start Date	:	10-26-05	OE Value : 0.00
Est Finish Date	:	11-15-05	
Act Finish Date	:		Est Margin : 0.000%
Drawings Reqd	:	No	Actual Margin : 0.000%
Ok for Approval	:		
Approval Rec'd	:		\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden	: 0.00	0.00	0.00		
<hr/>					
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/ (Loss)	: 0.00	0.00

Date: Saturday, 11/19/2005 11:40:00 AM
 User: Linda Lacelle

**INVENTORY ITEMS PICKED
FOR SLIP NUMBER 62**

Project No.	:	Drawing Number	: D3159 REV B
Customer	: Dart Helicopters Services	Drawing Name	: BRACKET ASSEMBLY
Part Number	: D3159044	Due Date	: / /
Job Number	: 24707	Qty	: 7
		Slip #	: 62

		Location	Store	Picking	Lot No.	Serial No.	Req'd	Taken
1.0	M6061T6S063 6061-T6 .063 Sheet							
	Available 186.00	MAIN			18556	21.27	21.2700 sf	
7.0	MS21061L06 Nutplate							
	Available 7.00	MAIN			11735	7.00	7.0000 Each	
8.0	MS20426AD34 RIVET							
	Available 6345.00	MAIN			15786	14.00	14.0000 Each	